

# Work Order ID 110094

December-17-13 9:14:52 AM

\*110094\*

Page 1

Item ID: D2229 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Doubler  
 Start Date: 12/17/13 Start Qty: 2.00 \*2\* \*6\* Cust Item ID:  
 Required Date: 12/17/13 Req'd Qty: 2.00 \*2\* \*6\* Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12-12-19 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2229	Rev B

100	FLOW WATER JET	0.00				6	0		<u>14-02-19</u>
*100*									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2229								
2024-063	Dwg Rev: <u>3</u>								
	Prog Rev: <u>3</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				6	0		<u>14-02-19</u>
*110*									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00				6			
*120*									
QC	Memo	0.00							
Quality Control									

DAS  
27  
9-89

14/2/19



# Work Order ID 110094

December-17-13 9:14:52 AM

**\*110094\***

Page 2

Item ID: D2229 Accept **\*N19000040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Doubler  
 Start Date: 12/17/13 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 12/17/13 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Small Fab Small Fab	Small Fab  Memo Deburr. No sharp edges	0.00  0.00		N/A	DAS 27 9-89				
140 <b>*140*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				6	14-2-20		
150 <b>*150*</b> QC Quality Control	QC7-Inspect Chemical Conversion Coat  Memo	0.00  0.00			DAS 27 9-89 14/2/20	6			

Work Order ID 110094

\*110094\*

Page 3

December-17-13 9:14:52 AM

Item ID: D2229

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Doubler

Start Date: 12/17/13

Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 12/17/13

Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Run Start

\*NR1\*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

\*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Identify as per dwg & Stock Location: ST007 0.00

\*160\*

Packaging

Memo

0.00

Packaging

6ex 14-2-21 DAS 28 9-89

170

QC21- Final Inspection - Work Order Release

0.00

\*170\*

QC

Memo

0.00

Quality Control

14-02-21

14-02-21

# Picklist Print

December-17-13 9:14:51 AM

Page 1

Work Order ID: 110094

Parent Item: D2229

Parent Item Name: Doubler

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: A02.06.05New IssueNG  
IPP Rev:B 07-08-15 Now On WaterJet JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 2024-T3 .063 sheet		Purchased	No			100	sf	252.7489	0.0521	1		Ac 17-02-19	

Location

Loc Qty

Loc Code

MAT022

252.7489

119916

0.2

121197

21.34

123096

11.4

123654

11.64

123701

16.1039

125341

87.94

125636

104.125

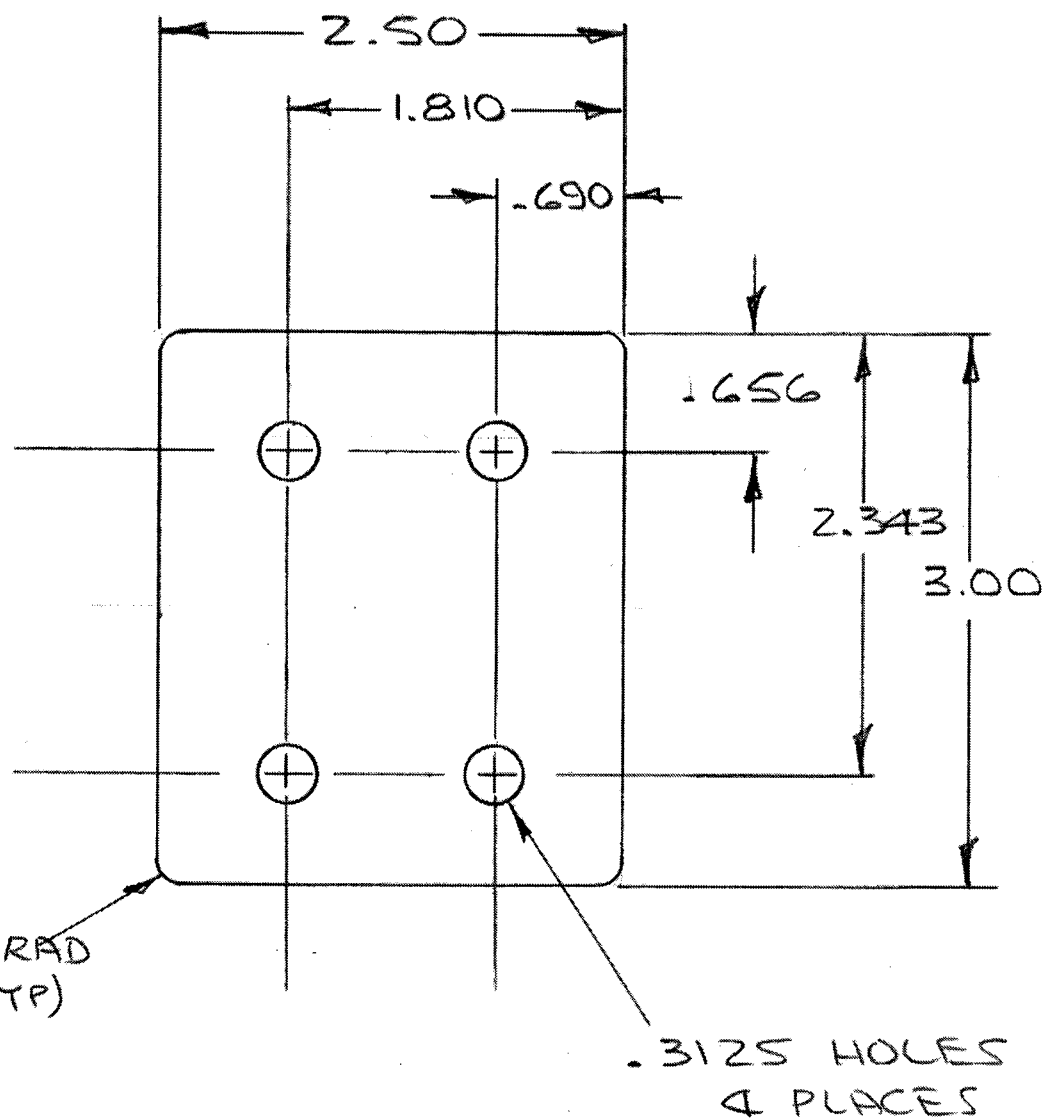
m127866 → ⑧



**DART**



DRAWN BRADLEY 94.3.28		<b>DART AERO ACCESSORIES INC</b> VICTORIA INTERNATIONAL AIRPORT, CANADA	
DESIGN BRADLEY 94.3.28		DRAWING NO. D2229	REV. B
		SHEET 1 OF 1	
		TITLE DOUBLER	
A	NEW ISSUE	94/3/28	9
B	ALODINE WAS ANODIZE	97/11/06	9



110094 MLS  
13-12-19

MATERIAL: 2024-T3 ALUMINUM  
.063 THICK

FINISH: ALODINE PER QSI 005-4.1